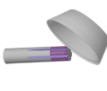


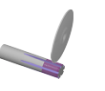






Forming Tap M3

A10-150

The excentric form of the tap is freely designable based on DXF, as well as the diameter along the thread. Pregrinding and Finishing using appropriate vitrified wheels combined with dressing on diamondrolls leads to a very effective and rapid process. The high speed process is fully supported by the powerful Fanuc control and its optimised parameters.

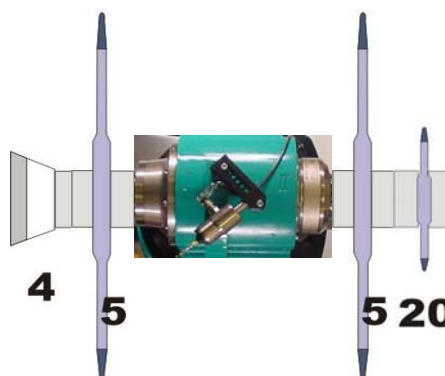
1. Cycletime for Production

Tool specifications				
Diameter 3.15 mm, Length of cutting edge 24 mm				
Material HSS				
Operations				
	Point Tip	Thread Pregr	Thread Finish	Thread O.D.
Feed [mm/Min]	150	8000	9000	9000
Power [kW]	1	1	1	1
Cutting feed [m/s]	32	50	50	24
Used wheels				
Grinding time [s]	11	45	40	40
Total cycle time	2 Min 16			

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

4 Ø75 11V9 B126
5 Ø200 14EE1 C280
20 Ø150 14EE1 C280



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR
Control: Fanuc 31i
Coolant: Synthetic Oil, pressure 10 bar
Software: Quinto 5

automatic Tailstock and Steadyrest
Dressing unit

responsible engineer: OP, 18.3.07

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, China

TECHNOLOGY
FOR TOOLING

